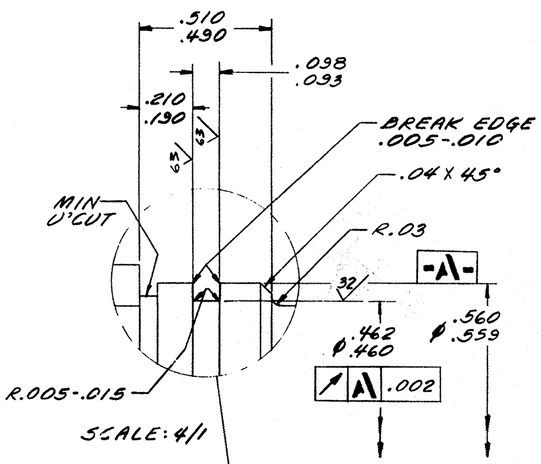
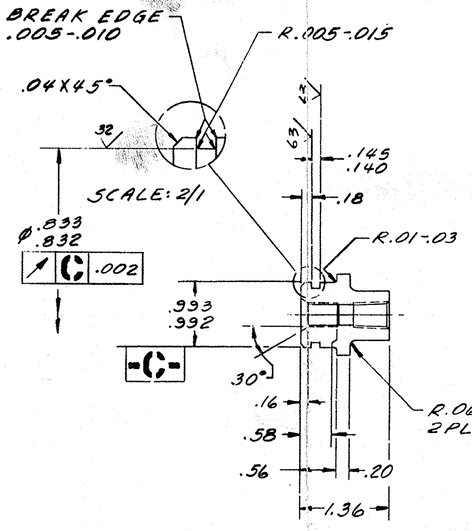
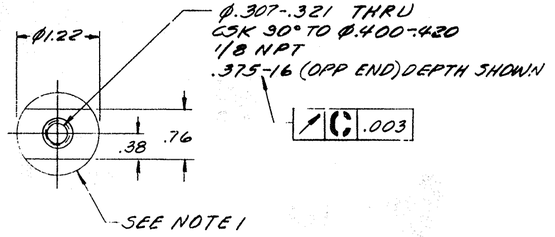
| REVISIONS | | | | | | |
|---|---|---|---|---|---|---|
| LTR | DESCRIPTION | DATE | AUTHORITY | DR | CK | MFR ENGR |
| | | | | | | |

CONTROLLED DOCUMENT
DATE 01-06-15 JOB# 01-15996-Q

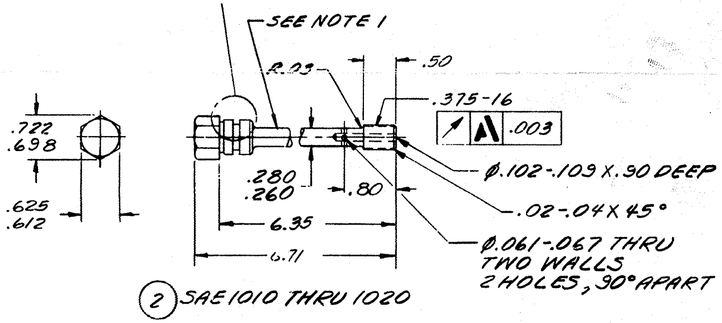
FILE COPY



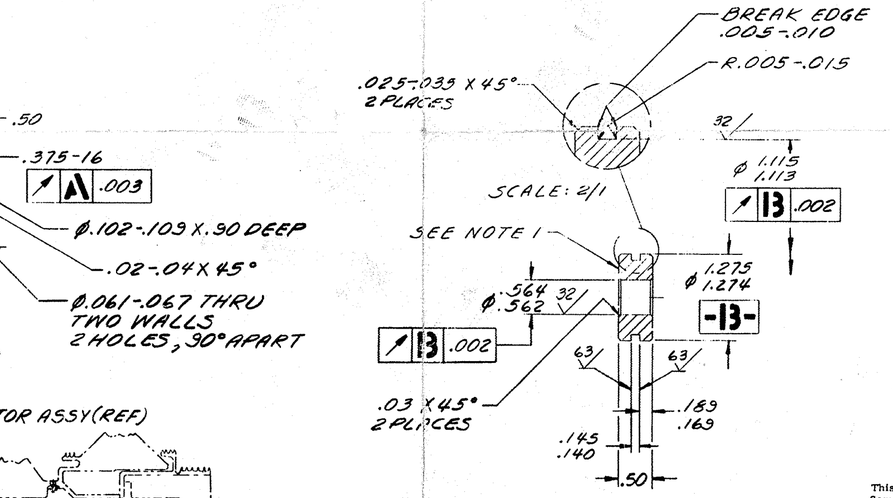



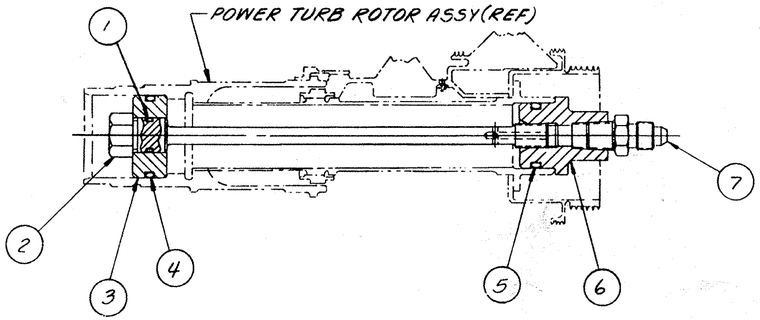

6 SAE 1010 THRU 1020




2 SAE 1010 THRU 1020




3 SAE 1010 THRU 1020




| | | | | | |
|---|---|---|---|---|---|
| 7 | 1 | CONNECTOR | 30780 | 4FBTX-S | PARKER |
| 6 | 1 | PLUG, INNER | | | STL |
| 5 | 1 | "O" RING | 02697 | 2-117-C557-70 | PARKER |
| 4 | 1 | "O" RING | 02697 | 2-121-C557-70 | PARKER |
| 3 | 1 | PLUG, OUTER | | | STL |
| 2 | 1 | BOLT, SPECIAL | | | STL |
| 1 | 1 | "O" RING | 02697 | 2-013-C557-70 | PARKER |
| ITEM NO. | NO REQD | NOMENCLATURE OR DESCRIPTION | CODE IDENT | PART OR IDENTIFYING NO. | |

- A PART IDENTIFICATION ITEM NUMBER(S) ARE SHOWN SECTIONED ON THIS DRAWING, EXCEPT WHERE A NUMBER APPEARS ON THE PART ITSELF.

NOTES:
1. ETCH IN LOCATION SHOWN AT DETAIL THE P/N ("23006303-2" ETC) ON ITEMS 2,3 AND 6 USING .12 HIGH FIGURES
2. BLACK OXIDE ITEMS 2,3 AND 6 PER AMS 2485

REF—

REDUCED PRINT

USED ON ENGINE MODELS:
250-B15G, C18ALL, B17/B/C, C20/B/F, T63-A-720

ITEM NUMBERED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG

This data is furnished with the understanding that it will be used for Service, Maintenance and Overhaul purposes only and not to Manufacture or procure the Manufacture of the part(s) shown and/or described. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of the Detroit Diesel Allison Division of GMC.

BREAK SHARP EDGES .020 UOS

| GEOMETRIC CHARACTERISTIC SYMBOLS | | |
|---|---|---|
| FLATNESS | ANGULARITY | (M) OR MMC (MAX MATL CONDITION) |
| STRAIGHTNESS | RUNOUT | (S) OR RFS (REGARDLESS OF FEATURE SIZE) |
| ROUNDNESS | TRUE POSITION | |
| CYLINDRICITY | CONCENTRICITY | (P) PROJECTED TOL ZONE |
| PROFILE OF A LINE | SYMMETRY | |
| PROFILE OF A SURFACE | XXXX BASIC DIM. | DATUM TARGET |
| PERPENDICULARITY | Ø DIAMETER | |
| PARALLELISM | -A- DATUM IDENT | XXX DIM. NOT TO SCALE |

UNLESS OTHERWISE SPECIFIED:
ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC
ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS
SEPARATE TRUE POSITION CALLOUTS MAY BE CAGED SEPARATELY REGARDLESS OF DATUM REFERENCE
RUNOUTS ARE CIRCULAR.

| | |
|---|---|
| UNLESS OTHERWISE SPECIFIED | |
| TOL. ON ANGLES ± 1° | |
| TOL. ON DECIMALS ± .02 | |
| MATL | SEE ITEM |
| HEAT TREAT AND HARDNESS | — |
| SURFACE TREAT | NOTED |

| | |
|---|---|
| DRAWING DATE | 81-11-4 |
| DRAFTSMAN | H.R.PECK / H.R.P. |
| CHECKER | MILLER/MJ |
| APPROVED | [illegible] |
| METALLURGY | |
| ENGR 1 | G.R. SWOLD |
| ENGR 2 | |
| FINAL | E.J. REAGAN |
| WELD OR BRAZE | |
| INSPECTION | |

| | |
|---|---|
| DRAWING PRACTICE | |
| SURFACE TEXTURE | |
| SCREW THREADS | |
| GENERAL SPECIFICATIONS | |

AMS 2485
SAE 1010 THRU 1020
LOCAL SPECS. (REF)
Alternate Mat.
Stress Proff.
dg. 4/2/15
SPEC. SUMMARY

Detroit Diesel Allison
Division of General Motors Corporation
Indianapolis Operations

TITLE
FIXTURE-PRESSURE TEST, POWER TURBINE ROTOR

MODEL (FIRST USAGE)
APPLICATION: SEE SEPARATE PARTS LIST

| SIZE | FSCM No. | DWG. No. |
|---|---|---|
| D | 73342 | 23006303 |

SCALE 1/1 UOS SHEET

DWG NO 23006303

FORM 852D-REV 7-81